

**FLEXIBLE HYDRAULIC BRAKE LINE ASSEMBLY  
FOR MOTOR VEHICLE WHEELS**

Abstract of the Disclosure

Hydraulic fluid is supplied to hydraulic brake cylinders for calipers and brake shoes of a motor vehicle through brake line assemblies each including a flexible multi-layer high pressure brake hose having an end portion receiving an inwardly forged end portion of a small diameter high pressure steel tube. A metal collar receives each tube and is secured to the tube by a crimp or threads and/or a spring retaining washer, and is also crimped onto an end portion of the hose. The opposite end portion of each metal tube is flared and receives a tubular flare nut which may be threaded directly into a brake caliper or a brake control valve. The collar may be progressively formed from sheet metal, and may be secured to the tube by a non-circular crimp. Circumferentially spaced ears may be formed on the tube and project into corresponding grooves within the collar.

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